

Work Order ID 150418

Wednesday, August 24, 2016 11:54:20 AM

150418

Page 1

Item ID: D4928-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut

Start Date: 8/17/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: **DAS**

Date:

Tooling:

Date:

Run Start ***NR1***QC: **21**
9-89

Date:

AUG 29 2016

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D4928	C
-------	---

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.92

Doosan Lathe

1- Turn as per Folio FB244

Rev: **AA** & Dwg D4928 Rev: **C**

2- Deburr

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.01

Quality Control

6 **16-10-17****6** **16-10-17**

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Wednesday, August 24, 2016 11:54:20 AM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 8/17/2016 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 8/24/2016 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.02

Quality Control

130

Outsource process - NDT per QSI038 4.1

0.00

130

Outsource2

Memo

0.00

Outsource process - NDT

ISSUE P/O : 33960

C OF C IS REQUIRED

140

Receive & Inspect for Damage & Mat'l Certs

0.00

140

Packaging

Memo

0.02

Packaging

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Work Order ID 150418

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Page 3

Item ID: D4928-1

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut

Start Date: 8/17/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 8/24/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.02

Quality Control

6

DAS
38
9-89

OCT 25 2016

160

Identify as per dwg & Stock Location: ST 138

0.00

160

Packaging

Memo

0.01

Packaging

6x

DAS
26
9-89

OCT 25 2016

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.08

Quality Control

16/10/26 JF

DAS
21
9-89

OCT 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Wednesday, August 24, 2016 11:54:19 AM

Page 1

Work Order ID: 150418

150418

Parent Item: D4928-1

D4928-1

Parent Item Name: Strut

Start Date: 8/17/2016

Required Date: 8/24/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 14-04-17 JLM VERIFIED BY

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R0.750		Purchased	No				f	37.5260		2.368421			

M174PH-H900R0 750

17-4 SS H900 ROUND BAR 0.750"

Location

Loc Qty

Loc Code

MAT031

37.526

M129892

37.526

(5)
2.5' 16-10-16

DQA: _____ Date: _____



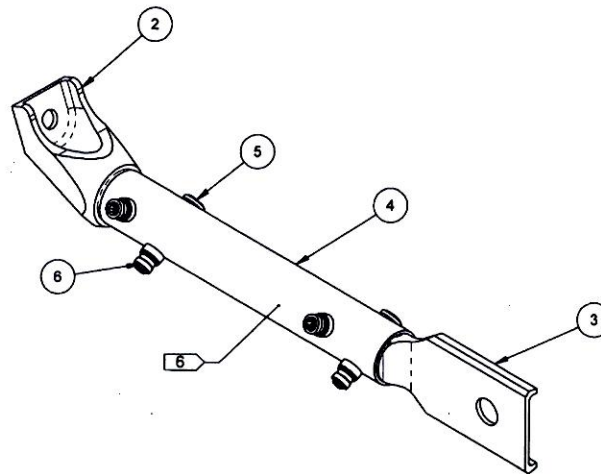
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4928-041	LEG ASSEMBLY, LH
2	1	D4883-3	END FITTING
3	1	D4884-3	END FITTING, EYE
4	1	D4928-1	STRUT
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



D4928-041 LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-062-102-001)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.58 lbs
- 8) ALIGN PILOT HOLES IN D4928-1 WITH PILOT HOLES IN D4883-3 & D4884-3.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9970
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9970
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

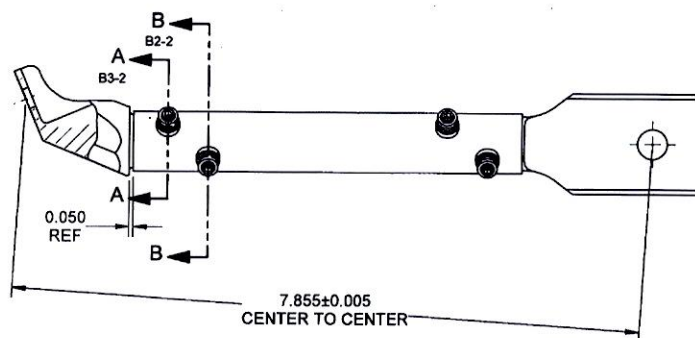
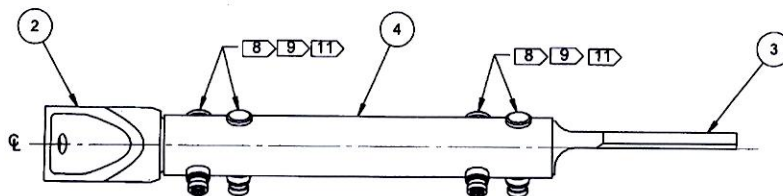
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 150418 MJS
1608-29

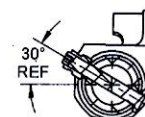
RELEASED
2014-07-07

C	HL32PB5-12 WAS HL20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 6) (ZN A8-5); ADD LH/RH (ZN B4-1, A4-2, B4-3, B4-4)	RF	14.06.24
B	REVISE NOTES 6), 7) & 9) (ZN A8-1); ADDED BELL P/N: ADD -042 (ZN B4-3, B4-4); REVISE SECTIONS A-A, B-B (ZN B2-2, B3-2)	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4928	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

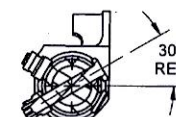
APPROVED



D4928-041 LEG ASSEMBLY, LH
AUXILIARY VIEW



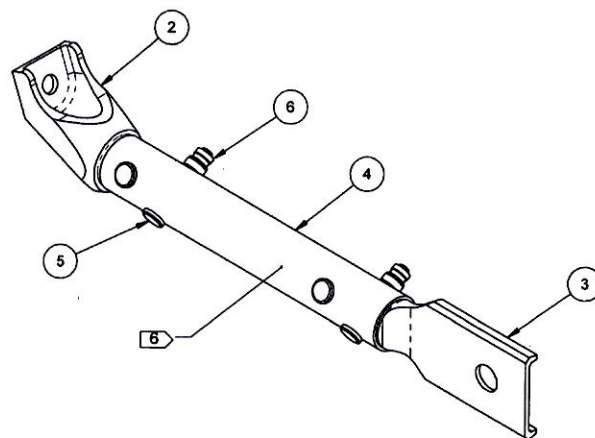
SECTION A-A C7-2
2 PL



SECTION B-B C7-2
2 PL

RELEASED
2014-07-07

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	HS	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4928	SHEET 2 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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D4928-042 LEG ASSEMBLY, RH
(EQUIVALENT TO BELL P/N 206-062-102-001)

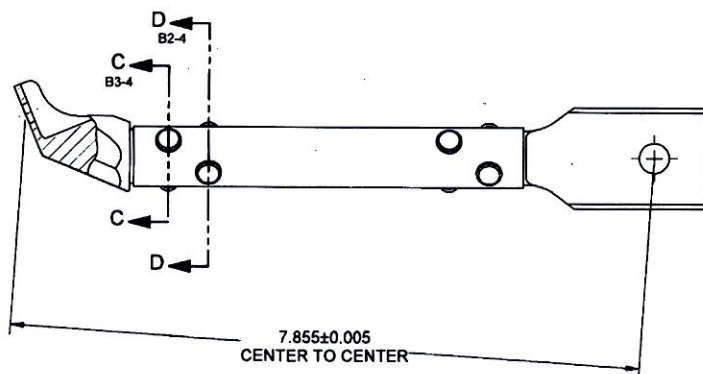
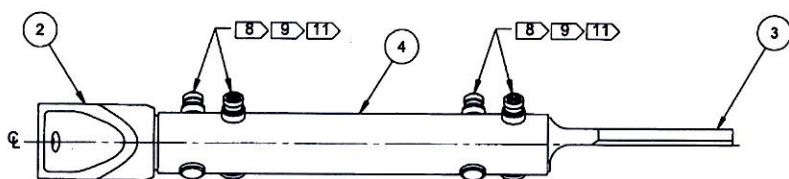
ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4928-042	LEG ASSEMBLY, RH
2	1	D4883-3	END FITTING
3	1	D4884-3	END FITTING, EYE
4	1	D4928-1	STRUT
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR

NOTES:

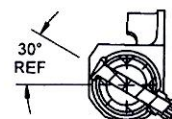
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.58 lbs
- 8) ALIGN PILOT HOLES IN D4928-1 WITH PILOT HOLES IN D4883-3 & D4884-3.
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RELEASED
2014-07-07

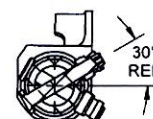
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4928	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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D4928-042 LEG ASSEMBLY, RH
AUXILIARY VIEW



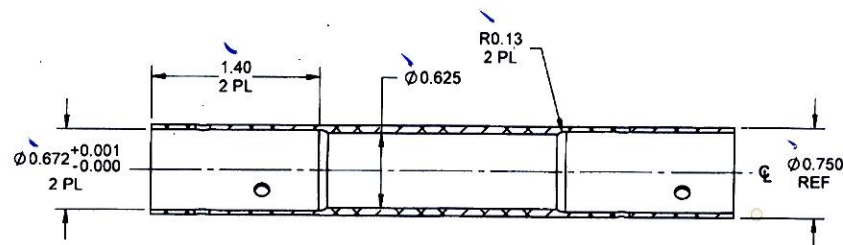
SECTION C-C C7-4
2 PL



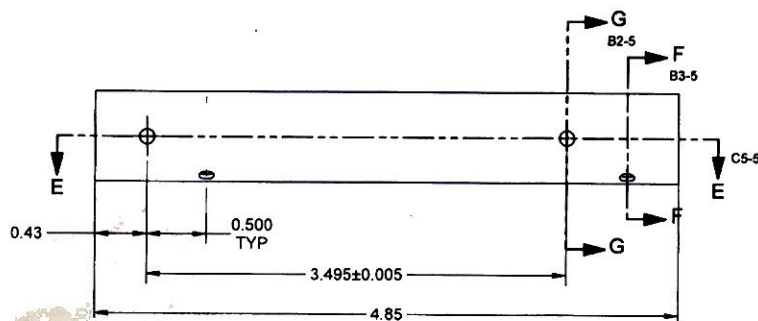
SECTION D-D C7-4
2 PL

RELEASED
2014-07-07

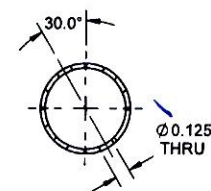
APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	HS	DRAWING NO. D4928	REV. C
	MFG. APPR.	JFS	SHEET 4 OF 5	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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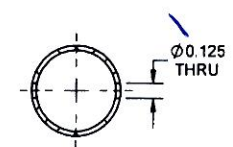
SECTION E-E B4-5



D4928-1 STRUT



SECTION F-F C4-5
2 PL



SECTION G-G C4-5
2 PL

NOTES:

- 1) MATERIAL: 17-4 PH /S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.15 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	VS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4928	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
DATE	14.06.24	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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2014-07-07



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33960**

Purchase Order Date 10/18/2016

PO Print Date 10/21/2016

Page Number 2 of 3

Order From :
SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

VC-SKY001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905-678-5636

Ship To Contact
Ship To Phone
Ship Via: Delivered
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

3	151207	D212-725-1-007 COLLECTIVE BELL CRANK	10/19/2016	6.00	\$0.00	\$0.00
			Yes 10/19/2016			

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$0.00

4	150328	D4867-1 STRUT	10/19/2016	6.00	\$0.00	\$0.00
			Yes 10/19/2016			

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$0.00

5	150418	D4928-1 STRUT	10/19/2016	6.00	\$0.00	\$0.00
			Yes 10/19/2016			

LIQUID PENETRANT INSPECTION AS PER QSI 038 OR
LPI AS PER ASTM 1417 LEVEL 2

Line Total: \$0.00

Note:

10/21/2016

DAS
38
9-88

Sp/16-10-24



skyservice Work Order Traveler

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO29832	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 33960
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 12 STRUTS AS PER PO33960

6 STRUT , ITEM ID# D4928-1 , WORK ORDER ID# 150418

6 STRUT , ITEM ID# D4867-1 , WORK ORDER ID# 150328

Sp16-10-24

Action Taken:					Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN ZL-37, MPO13139, CLEANER SKC-S MPO15030, EMU. MPO15896, DEV. MPO15030, UV LIGHT M-20142					OCT 20 2016	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On
			<i>DAS 38 9-88</i>			

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: OCT 20 2016
Name: RAFIK MELIKIAN		